

Date: Thursday, 2/23/2006 10:24:37 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARM
Job Number	: 25933		
Estimate Number	: 11375		
P.O. Number	: N/A	Part Number	: D33871
This Issue	: 2/23/2006 S.O. No. : N/A	Drawing Number	: D3387 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: N/A	Material	: N/A
Written By	: <u>See Comment Below</u>	Due Date	: 3/22/2006 Qty: 8 Um: Each
Checked & Approved By	: <u>KJ 06.02.23</u>		
Comment	: Est:A 05.06.18 New Issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X06000	6061-T6 Bar .50" x 6.0"
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Comment: Qty.: 1.5685 f(s)/Unit Total : 12.5479 f(s)
 6061-T6 Bar .50" x 6.0"
 Material: 6061-T6/T651 (QQ-A-200/8)
 (M6061T6B0.500x06.000)
 Identify for D3387-1
 Batch: M1000 46

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blank: 6.000" x 0.500" x 17.800" long

SAD 06/03/05

8

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA511 and Dwg D3387
 Identify as D3387-1
 C'sink Ø0.375" as per Dwg D3387
 Tumble and Deburr NO sharp edges

ml 06/03/09

8

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 06/03/09

8

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 26/03/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/23/2006 10:24:37 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 25933

Part Number: D33871

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

Ep 06/03/10 ⑧

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Patrick

R 06/3/14 8

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

⑧ 06/03/15

Job Completion



U 06.03.14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	25933
Description: Arm		Part Number:	D3387-1
Inspection Dwg: D3387 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.125	+/-0.010	R 0.125	✓			
0.125	+0.020/-0.000	0.127	✓			
Ø0.375 x100°	+/-0.010	Ø0.373x100°	✓			
R0.032	+/-0.010	R0.032	✓			
0.500	+/-0.010	0.495	✓			
0.500	+/-0.010	0.501	✓			
7.577	+/-0.010	7.580	✓			
R0.125	+/-0.010	R0.125	✓			
Ø0.507	+0.000/-0.001	Ø0.5067	✓			
0.250	+/-0.010	0.252	✓			
1.347	+/-0.010	1.344	✓			
2.000	+/-0.010	2.001	✓			
1.000	+/-0.010	0.999	✓			
Ø0.191	+0.005/-0.000	Ø0.192	✓			
R0.300	+/-0.010	R0.300	✓			
2.033	+/-0.010	2.032	✓			
0.280 0.300	+/-0.010	0.297	✓			
0.222 0.188	+/-0.010	0.188	✓			
1.700	+/-0.010	1.701	✓			

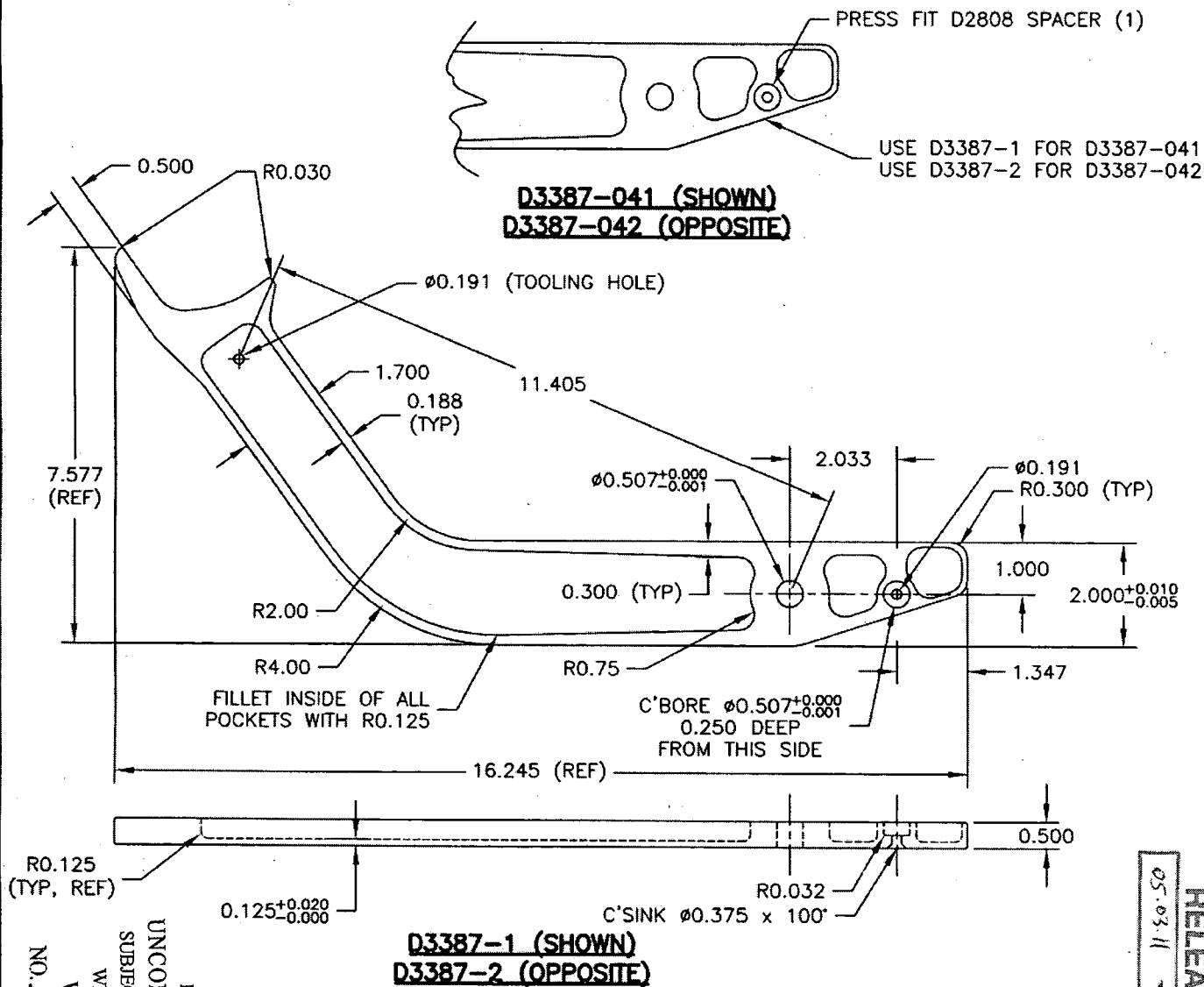
Measured by:	<i>JLM</i>	Audited by:	<i>En</i>	Prototype Approval:	N/A
Date:	06/03/09	Date:	06/03/09	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue	P/O D3387-041	KJ/JLM

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
DATE		D3387	SHEET 1 OF 1
05.01.18		TITLE	SCALE
		ARM	1:3
A	05.01.18	NEW ISSUE	

05.03.11



GENERAL NOTES

ORDER
 33
 AMENDMENT
 UT NOTICE
 COPIED COPY
 1) MACHINE PER DRAWING FILE "D3387-A.DWG"
 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11) 0.500 THICK
 (REF DART SPEC. M6061T6B0.500)
 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 5) ALL DIMENSIONS ARE IN INCHES

UNCONFIRMED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 25933

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